

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024975**Date Inspected:** 30-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BLAST SHOP#2**POST BLAST INSPECTION INTERNAL AND EXTERNAL OF TOWER HEAD, NORTH SHAFT LIFT-6****Description of Inspection:**

During the External & Internal post-blast visual inspection on North tower Lift-6, this Quality Assurance Inspector's (QA) discovered the defects required welding and Magnetic particle testing on weld and base material at the following locations:

- 1) Internal: Skin 'E' to top plate weld– Lack of sidewall fusion – 450 mm from A/E corner.
- 2) Internal: A/B corner weld bottom side– Porosity – on the face of the weld.

For further information, please see the attached pictures below.

POST BLAST INSPECTION INTERNAL AND EXTERNAL OF TOWER HEAD, WEST SHAFT LIFT-6**Description of Inspection:**

During the External & Internal post-blast visual inspection on West tower Lift-6, this Quality Assurance Inspector's (QA) discovered the defects required welding and Magnetic particle testing on weld and base material

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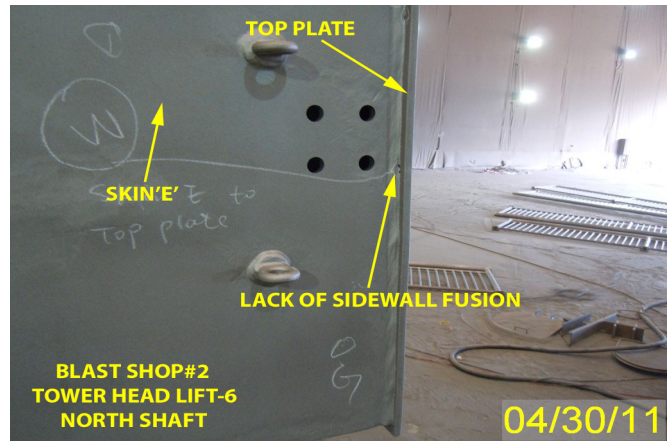
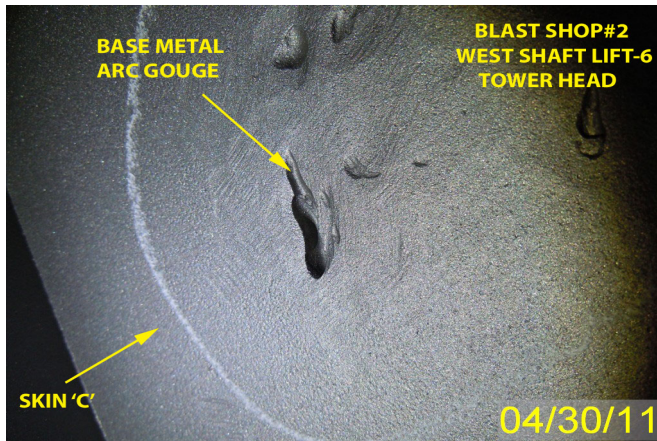
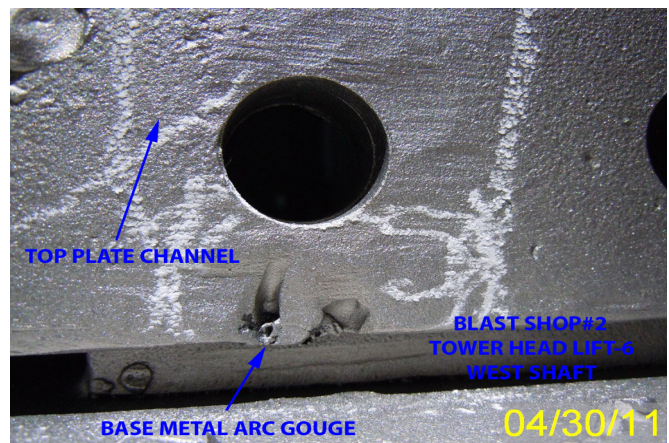
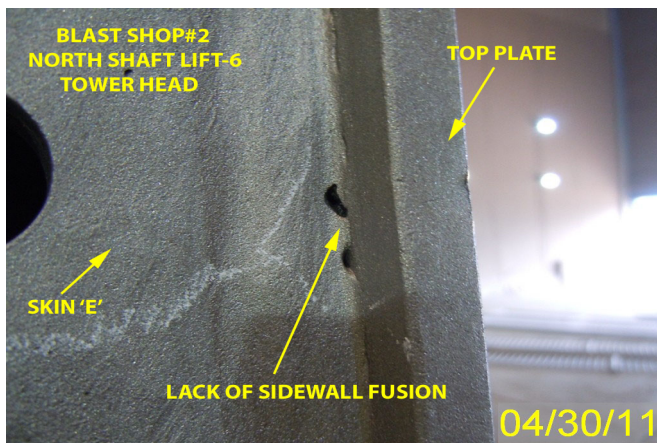
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at the following locations:

- 1) Internal: Skin 'C' – Base material arc gouge – 90 mm from top plate and 100 mm from B/C corner.
- 2) Internal: Skin 'A' – Base material arc gouge – 2000 mm from A/E corner.
- 3) Internal: Top plate channel – Base material arc gouge – 140 mm from Skin 'A'.
- 4) Internal: G' plate to 'F' plate weld – underfill – top side of the weld.
- 5) Internal: Top plate – Base material arc gouge – on the stiffener near manhole.

For further information, please see the attached pictures below.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho - 15002048250, who represents the Office of Structural Materials for your project.

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| Inspected By: | Kumar,Sandeep | Quality Assurance Inspector |
| Reviewed By: | Clifford,William | QA Reviewer |
